Work Order ID 84021

Duplicate

84021

May-30-12 3:50:20 PM

Item ID: D206-667-101TRN **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Crosstube Turning Detail

Start Date: 01/05/2012 **Start Qty:** 1.00 *1*

Required Date: 15/05/2012 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MLJ **Date:** 12/05/31 **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D206-667-141	Rev C								
100		0.00							
100	MORI SEIKI CNC LATHE LARGE					1	Ø	KC	12-7-22
Mori Seiki	**Memo**	0.00							
Mori Seiki CNC Lathe Large	1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA083 2-Turn first side as per Folio FA083 3-Blend transition lines only, **do not sand whole tube**: FOLIO REV: DWG REV: C *Use mill bastard file, brush file repeatedly with file card. *Do not use sandpaper coarser than 320 grit.								
110	QC1- Inspect dimensions to dimension sheet	0.00				1	Ø	KC	12-7-22
110									
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 84021

May-30-12 3:50:20 PM

84021

Item ID: D206-667-101TRN **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Crosstube Turning Detail

Start Date: 01/05/2012 **Start Qty:** 1.00 *1* **Cust Item ID:**

Required Date: 15/05/2012 **Req'd Qty:** 1.00 *1* **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120	MORI SEIKI CNC LATHE LARGE					1	Ø	KC	12-7-22
Mori Seiki	**Memo**	0.00							
Mori Seiki CNC Lathe Large	1-Turn second side as per Folio FA083 2-Blend transition lines only, **do not sand whole tube**: *Use mill bastard file, brush file repeatedly with file card. *Do not use sandpaper coarser than 320 grit. FOLIO REV:_____ DWG REV: C 3-Remove sand and plugs								
130	QC1- Inspect dimensions to dimension sheet	0.00				1	Ø	KC	12-7-22
130									
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 84021

May-30-12 3:50:20 PM

84021

Item ID: D206-667-101TRN
Revision ID:
Item Name: Crosstube Turning Detail
Start Date: 01/05/2012 **Start Qty:** 1.00 *1*
Required Date: 15/05/2012 **Req'd Qty:** 1.00 *1*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** ____ **Date:** ____ **Tooling:** ____ **Date:** ____
QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC8- Inspect parts - second check	0.00							
140									
QC	**Memo**	0.00							
Quality Control									

DAS 03 8-89 12-7-23

145		0.00							
145									
Crosstubes	**Memo**	0.00							
Crosstubes	GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.								

Run 12-7-23

150	~~Crosstubes Chemical Conversion~~	0.00							
150									
HandFXtube	**Memo**	0.00							
Hand Finishing Crosstubes	1- Pressure wash x-tube inside and out 2- Acid Etch x-tube inside and out. Use Red Scotch Brite.								

Run 12-7-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Item ID: D206-667-101TRN
Revision ID:
Item Name: Crosstube Turning Detail
Start Date: 01/05/2012 **Start Qty:** 1.00 *1*
Required Date: 15/05/2012 **Req'd Qty:** 1.00 *1*
Reference:

Accept *N900040100*
Setup Start *NS1*
Stop *NS2*
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5-Inspect Chemical Conversion Coat	0.00	DAS 03 2-89			12-7-24			
	Memo	0.00							
170 *170* Packaging Packaging	Packaging	0.00				12-7-24			
	Memo Identify and stock in kanban rack Location: LG	0.00							
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00				MLJ 12/07/25			
	Memo	0.00							

MLJ 12/07/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

May-30-12 3:50:23 PM

Work Order ID: 84021

84021

Parent Item: D206-667-101TRN

D206-667-101TRN

Parent Item Name: Crosstube Turning Detail

Start Date: 01/05/2012 **Required Date:** 15/05/2012

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 remove polish EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6001-105		Manufactured	No			110	Each	18.0000	1	1			

D6001-105

Crosstube, Material

**

Location	Loc Qty	Loc Code
LG	18	
29115	18	

1

KC 12-7-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** *Chief Eng / Prod Mgr*	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	84021
Description: Crosstube Assembly (206B High Fwd)	Part Number:	D206-667-141
Inspection Dwg: D206-667-141 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.245	✓		VERN	CNC-08
	2.074	+0.005/-0.000	2.078	✓			
	2.074	+0.005/-0.000	2.079	✓			
	2.114	+0.005/-0.000	2.119	✓			
	2.154	+0.005/-0.000	2.159	✓			
	2.194	+0.005/-0.000	2.197	✓			
	2.234	+0.005/-0.000	2.239	✓			
	0.110	+/-0.010	.110	✓			
	0.300 x 30°	+/-0.010	.300	✓			
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010	.500	✓		RG	—
	4.438	+/-0.030	4.450	✓		RG	—
				✓		VERN	CNC-08
SIDE B	2.240	+0.005/-0.000	2.245	✓		VERN	CNC-08
	2.074	+0.005/-0.000	2.076	✓			
	2.074	+0.005/-0.000	2.079	✓			
	2.114	+0.005/-0.000	2.119	✓			
	2.154	+0.005/-0.000	2.159	✓			
	2.194	+0.005/-0.000	2.198	✓			
	2.234	+0.005/-0.000	2.239	✓			
	0.110	+/-0.010	.110	✓			
	0.300 x 30°	+/-0.010	.300	✓			
	R0.063	+/-0.010	.063	✓		RG	—
	R0.500	+/-0.010	.500	✓		RG	—
	4.438	+/-0.030	4.438	✓		VERN	CNC-08
	93.18	+/-0.020	93.18	✓		TAPE	LG-22

Measured by:	KC	Audited by:	[signature]	Prototype Approval:	N/A
Date:	12-7-22	Date:	12-7-23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.24	New Issue (P/O D206-667-101)	KJ/JLM	
B	09.12.14	Dwg Rev updated	KJ	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Item	Qty -141	Part Number	Description
1	X	D206-667-141	CROSSTUBE ASSEMBLY (206B HIGH FWD)
2	1	D6001-105	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 84021 MLJ
12/05/13

DEO ATTACHED
DCN #11-615
11.07.26

UNDER REVIEW
06.13

RELEASED
08/11/12

GENERAL NOTES:

1) MATERIAL: MANUFACTURED FROM D6001-105
   FINISHED LENGTH = 93.18±0.020
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
   PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
   PAINT OUTSIDE PER DART QSI 005 4.2
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-141" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
7) WEIGHT: 11.3 lbs
8) PART IS SYMMETRIC ABOUT CENTERLINE.
9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
10) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

REV.	DESCRIPTION	BY	DATE
C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN C4-3, C5-3 & D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D206-667-141 — REV. C — SHEET 1 OF 4
MFG. APPR.		
APPROVED		TITLE: CROSSTUBE ASS'Y (206B HIGH FWD) — SCALE: NTS
DE APPR.		
DATE	08.11.06	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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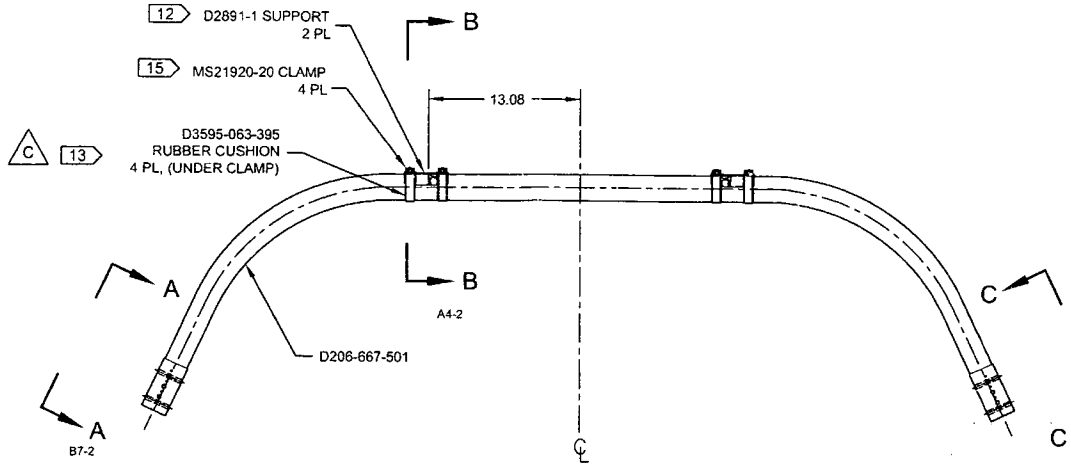
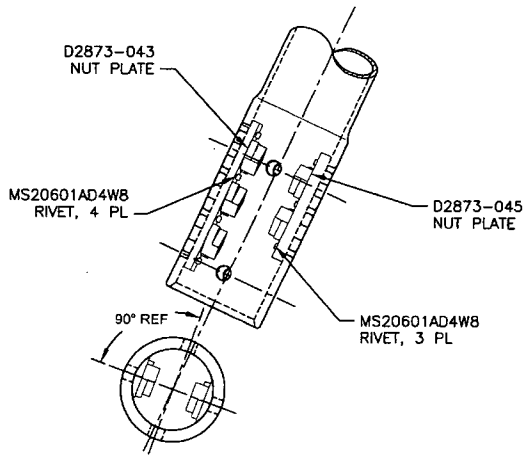
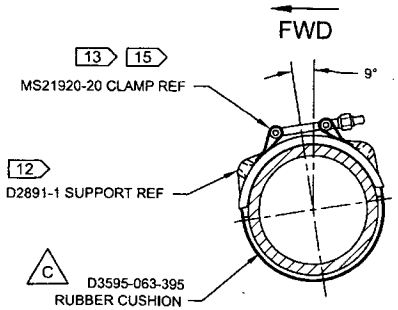
NOTE: Date & initial all entries

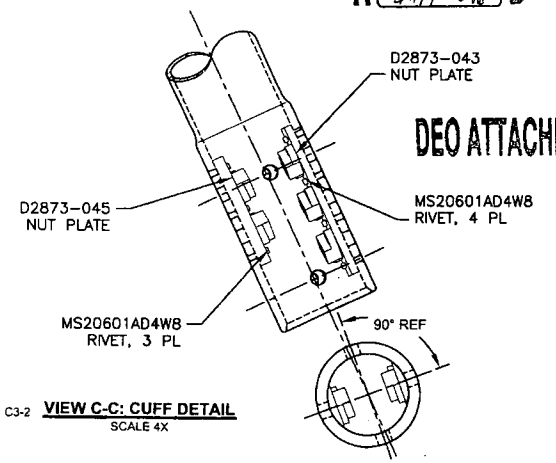




C6-2 **VIEW A-A: CUFF DETAIL**
SCALE 4X



D5-2 **SECTION B-B**
SCALE 5X



C3-2 **VIEW C-C: CUFF DETAIL**
SCALE 4X

e4021

ECN #11-615
11.07.28

UNDER REVIEW
11.07.28

RELEASED
08/11/12

DEO ATTACHED

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D206-667-141	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (206B HIGH FWD)	NTS
DATE	08.11.06		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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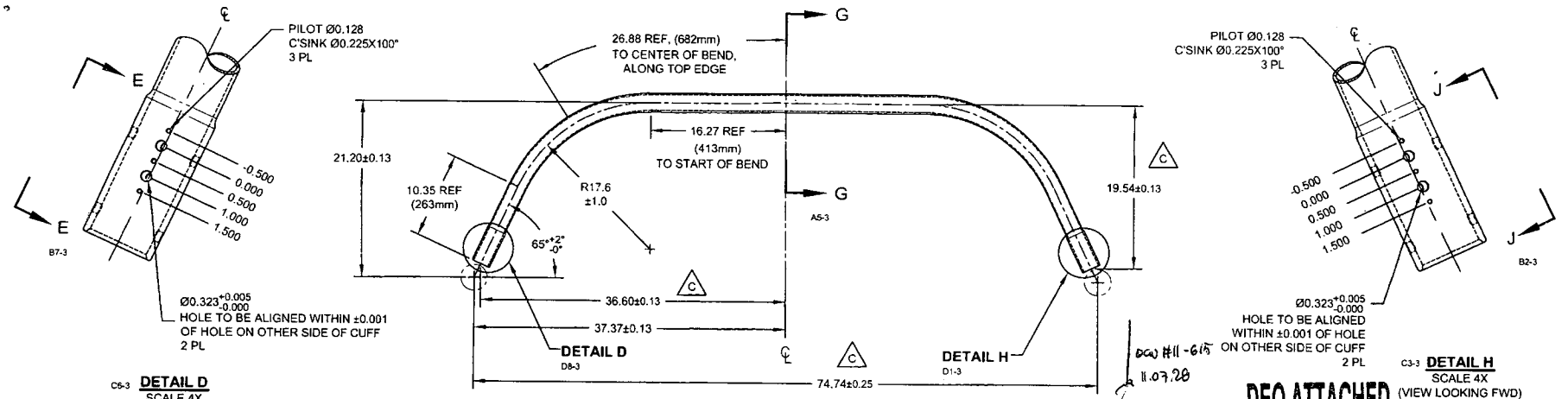
NOTE: Date & initial all entries

E4021



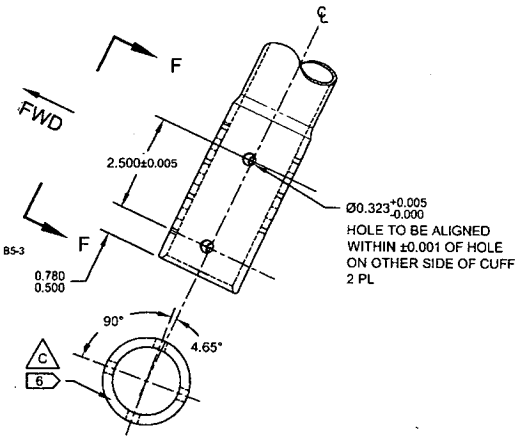
C6-3 **DETAIL D**
SCALE 4X
(VIEW LOOKING FWD)

C3-3 **DETAIL H**
SCALE 4X
(VIEW LOOKING FWD)

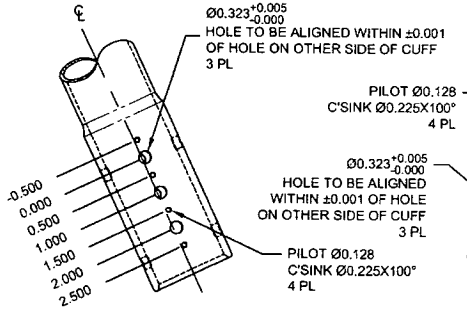
C 10 **D206-667-501**
BENDING AND DRILLING DETAIL
(VIEW LOOKING FWD)

DCN #11-615
11.07.28
UNDER REVIEW

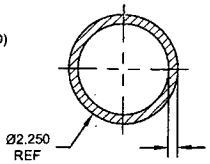
DEO ATTACHED
RELEASED
08/11/12 MB



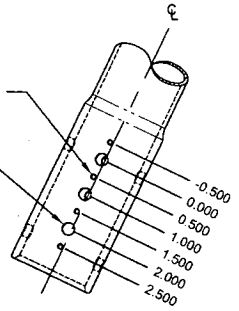
D8-3 **VIEW E-E:**
CUFF DETAIL
SCALE 4X



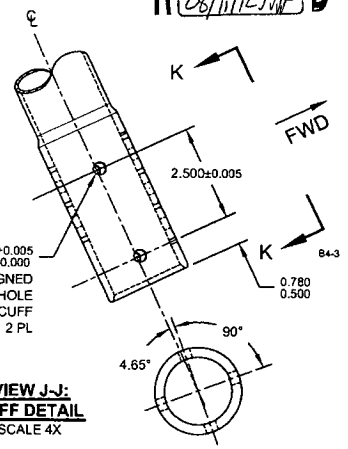
B7-3 **VIEW F-F**
(VIEW LOOKING AFT, ROTATED)



D4-3 **SECTION G-G**
SCALE 5X



B2-3 **VIEW K-K**
(VIEW LOOKING AFT, ROTATED)



D1-3 **VIEW J-J:**
CUFF DETAIL
SCALE 4X

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D206-667-141 REV. C SHEET 3 OF 4
MFG. APPR.		
APPROVED		TITLE CROSSTUBE ASS'Y (206B HIGH FWD) SCALE NTS
DE APPR.		
DATE	08.11.06	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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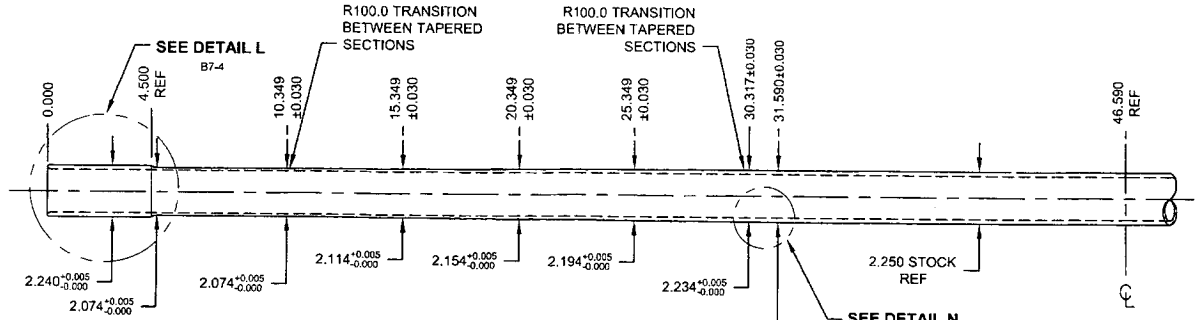
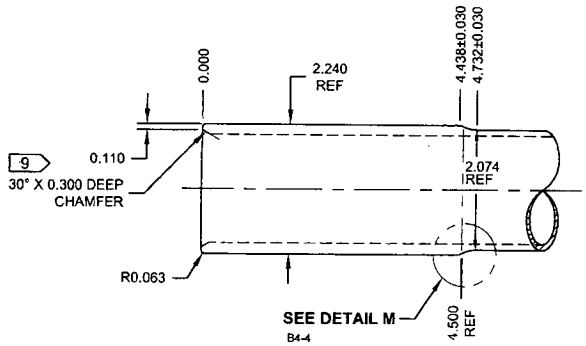
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

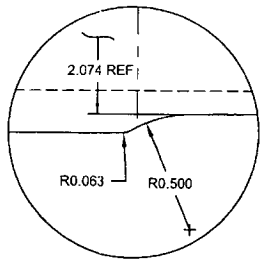
NOTE: Date & initial all entries



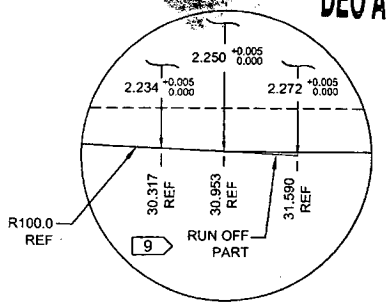
C TURNING DETAIL



D7-4 **DETAIL L: CROSSTUBE CUFF**
NOT TO SCALE



A6-4 **DETAIL M: CUFF TRANSITION**
NOT TO SCALE



C4-4 **DETAIL N: TAPER RUN-OFF**
NOT TO SCALE

E4021

BCN#11-615
11.07.28

UNDER REVIEW
11/06/13

DEO ATTACHED

RELEASED
08/11/12

DESIGN		DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D206-667-141	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (206B HIGH FWD)	NTS
DATE	08.11.06		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

64021

DRAWING NO.	TITLE	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO.	SHEET NO.	SCALE
D206-667-141	CROSSTUBE ASS'Y (206B HIGH FWD)			D206-667-141-C-1	SHEET 1 OF 1	NTS

DRAWN	CHECKED	MFG. APPR.	APPROVED	DE APPR.
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11/07/21	DATE 11.07.21

PURPOSE:
REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty -141	Part Number	Description
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

12) TO INSTALL D2891-1 SUPPORT: ABRADE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.

15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.

15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED 2011-07-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

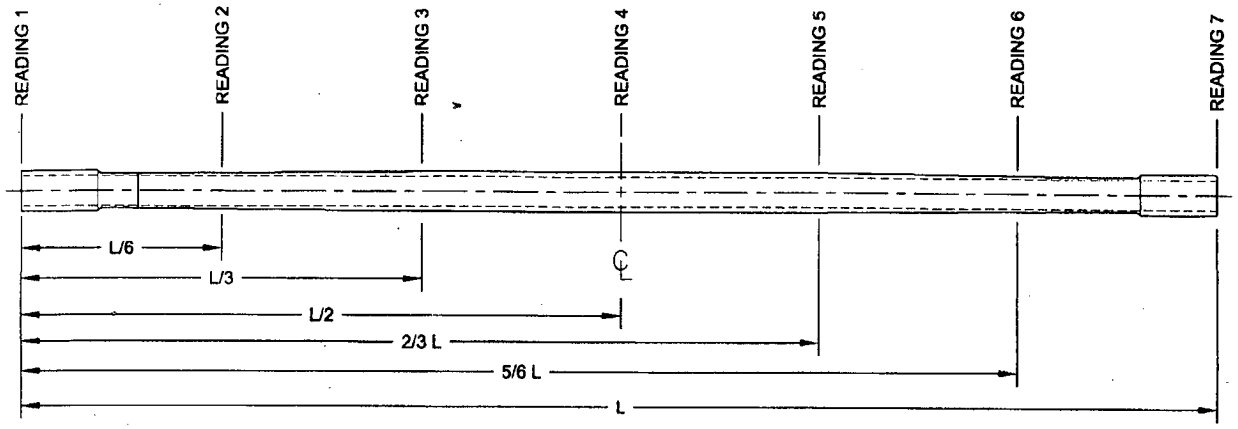
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Crosstube Assembly (206B High Fwd)	Part Number:	D206-667-141
Inspection Dwg: D206-667-141 **Rev:** C		Page 2 of 2

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	.197	.199	.200	.208	.011	0.030"
READING 2 L=	.134	.135	.139	.143	.009	
READING 3 L=	.199	.200	.204	.208	.009	
READING 4 L=	.195	.200	.204	.209	.014	
READING 5 L=	.195	.199	.205	.210	.010	
READING 6 L=	.132	.136	.138	.139	.007	
READING 7 L=	.188	.192	.204	.204	.016	

Calibration Result

Actual Block Thickness: 100 - 500

Sitescan 250 Measured Thickness: 100 - 500

Measured by:	KC	Audited by:		Preliminary Approval:	
Date:	12-7-23	Date:	12-7-23	Date:	

Rev	Date	Change	Revised by	Approved
A	06.10.24	New Issue (P/O D206-667-101)	KJ/JLM	
B	09.12.14	Dwg Rev updated	KJ	
C	12.06.04	Wall thickness form added	KJ	

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Crosstube	☐	Water Jet	☐	Engineering	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐	Quality	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Large Fab	☐	Composite	☐	Supplier	☐		☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____